

Date: Monday, 6/12/2006 3:48:57 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PROP ARM
<b>Job Number</b> : 27527	
<b>Estimate Number</b> : 10321	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2730
<b>This Issue</b> : 6/12/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2730 REV B1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 24638	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 6/30/2006
<b>Checked &amp; Approved By</b> : [Signature]	<b>Qty:</b> 20 <b>Um:</b> Each
<b>Comment</b> : Est D 0204.16 Added dwg Rev.B1 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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**Comment:** Qty.: 2.9750 f(s)/Unit Total : 59.4993 f(s)  
 304/316 Seamless Tubing, 1/2" O.D. x 0.035" wall  
 (M304TRO500W035)

Batch

M 101359 x 15  
 1100920 x 5

FF 06-06-22

20

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC  
 Punch to length as per Dwg D2730

FF 06-06-22

20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 1-Drill as per dwg D2730  
 2-Deburr

FF 06-06-22

20

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

06-06-23

20

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

SC  
 Q-22

06-06-29

20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: LD Date: 06/06/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM

Job Number: 27527

Part Number: D2730

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M 06 29*



*(20)*

Comment: INSPECT POWDER COAT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57147*

*H.M 06-06-29*

*(20)*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D7 06/06/30*

*(20)*

Job Completion



*U D6.06.30*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

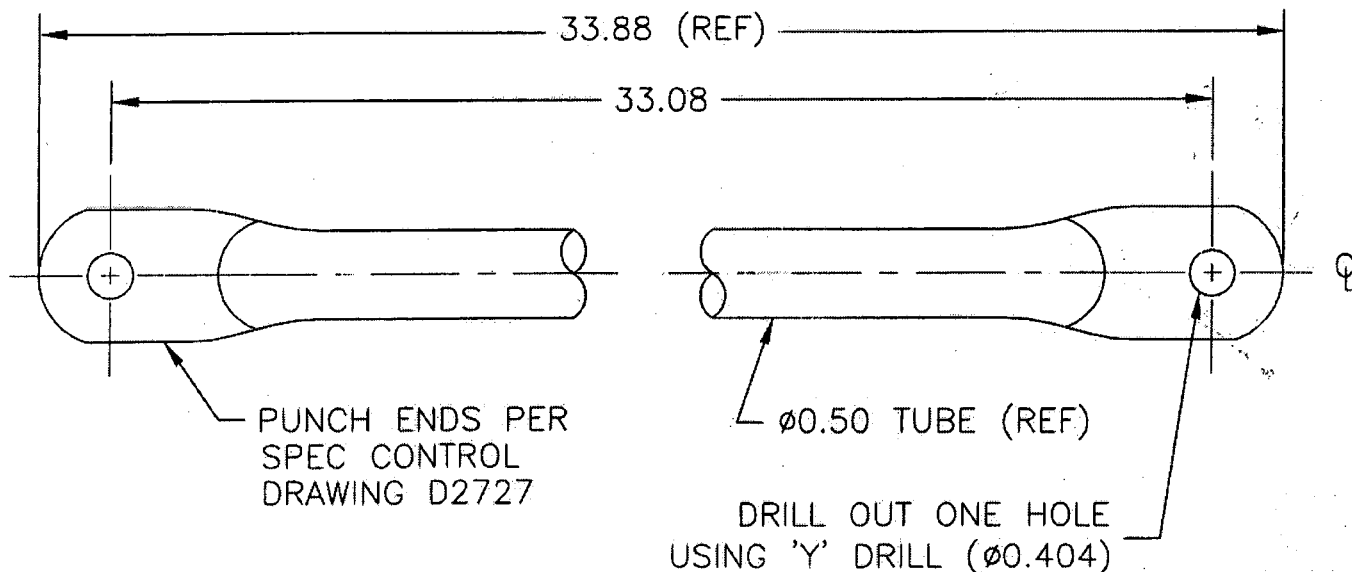
NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2730	REV. 8 SHEET 1 OF 1
DATE 00.06.20		TITLE PROP ARM	SCALE NTS
A	98.04.20	NEW ISSUE	
B	00.06.20	33.88 WAS 33.25; 33.08 WAS 32.45	
BI	<i>CPH</i> 02.03.22	ADD FINISH	

RELEASED  
00.06.27 *[Signature]*



MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE SEAMLESS TUBE IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27527*

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